

Monday, April 02, 2012 3:43:19 PM

April 11, 1984

Page 1

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

*** 1 ***

Cust Item ID:

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Date: 12/04/02 Tooling:

Date:

Stop *NR2*

QC:

Date: _____ **SPC (Y/N):** _____

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3690	Rev C

100 Pick Kit

0.00

100

Packaging Memo

0.00

Packaging

110

0.00

110

Small Fab

0.00

Small Fab

Memo

Small Fab

1- transfer drill D3697-041 and D3698-1 in D3690-1 and assemble as per dwg D3690

2- scribe batch # and part # as per dwg

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 82544

82544

Page 2

Monday, April 02, 2012 3:43:19 PM

Item ID: D3690-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Glareshield Assembly

Start Date: 4/2/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/17/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	SprayPaint	0.00							
130									
SprayPaint	Memo	0.00							
Spray Painting	1- Mask hatched areas (6 pls) on inside of the part prior to painting as per dwg								
	2-Paint D3690-041 assy flat black using Basf Glasurit 22 Line code SFA39.50 per Dart QSI 005 4.2								
140	QC14- Inspect Spray Paint	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

AP 12-4-18 ①

12-04-18 ①

1424/20

12/4/23

MF 12-04-20

ID + STOCK

PN 82540

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, April 02, 2012 3:43:23 PM

Page 1

Work Order ID: 82544

82544

Parent Item: D3690-041

D3690-041

Parent Item Name: Glareshield Assembly

Start Date: 4/2/2012

Required Date: 4/17/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-04-29 new issue DD verified by:ec
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec
IPP Rev:C 08-09-08 added painting DD verified by:EC
IPP Rev:D 08-10-07 revC as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status															
AN960JD3 *AN960.ID3* Washer		Purchased	No				Each	141.0000	**	2	①		FF 12/04/13															
<table><tr><td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td></tr><tr><td>ST337A</td><td>141</td><td></td></tr><tr><td>107989</td><td>141</td><td></td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	ST337A	141		107989	141							
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																										
ST337A	141																											
107989	141																											
CR3213-4-03 *CR3213-4-03* rivet		Purchased	No				Each	174.0000	**	35	①		FF 12/04/13															
<table><tr><td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td></tr><tr><td>ST331</td><td>100</td><td></td></tr><tr><td>120521</td><td>100</td><td></td></tr><tr><td>ST332</td><td>74</td><td></td></tr><tr><td>116081</td><td>74</td><td></td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	ST331	100		120521	100		ST332	74		116081	74	
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																										
ST331	100																											
120521	100																											
ST332	74																											
116081	74																											
D3690-1 *D3690-1* Glareshield		Manufactured	No				Each	0.0000	**	1	①		FF 12/04/13															
D3697-041 *D3697-041* Tube Assembly		Manufactured	No				Each	0.0000	**	1	①		FF 12/04/13															

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 2

Monday, April 02, 2012 3:43:23 PM

Work Order ID: 82544

82544

Parent Item: D3690-041

D3690-041

Parent Item Name: Glareshield Assembly

Start Date: 4/2/2012

Required Date: 4/17/2012

Start Qty: 1.00

Required Qty: 1.00

D3698-1

Manufactured No

Each

5.0000

1

D3698-1

Support Angle

**

①

FF 12/04/13

Location

Loc Qty

Loc Code

ST241A

5

59244

5

1

MS20426AD3-5

Purchased

No

Each

12,478.00

2

MS20426AD3-5

Rivet

**

①

FF 12/04/13

Location

Loc Qty

Loc Code

ST316

12478

4179

664

4444

5654

4533

6160

2

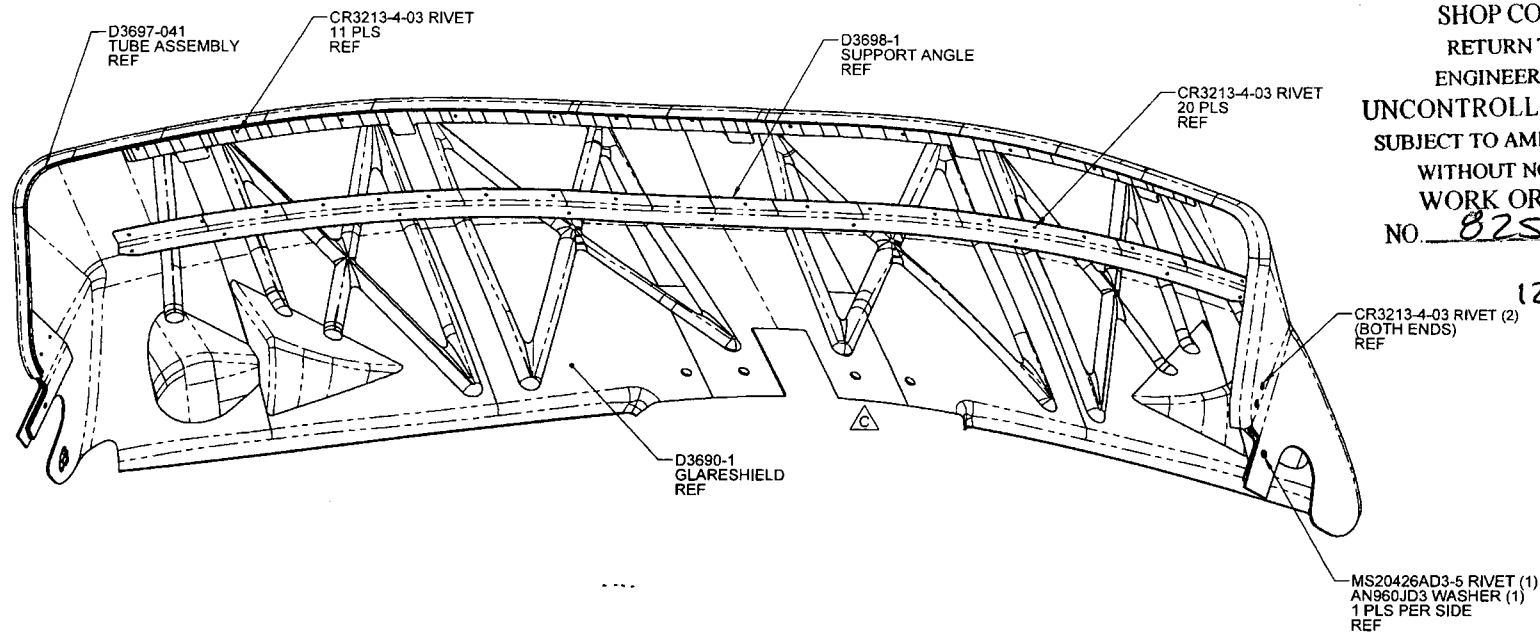
Dart Aerospace Ltd

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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82544
MLJ
12/04/02

RELEASED
28-09-16-17

PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3690-041	GLARESHIELD ASSEMBLY
1	D3690-1	GLARESHIELD
1	D3697-041	TUBE ASSEMBLY
1	D3698-1	SUPPORT ANGLE
2	AN960JD3	WASHER (OR NAS1149DN332J)
2	MS20426AD3-5	RIVET
35	CR3213-4-03	RIVET

D3690-041 GLARESHIELD ASSEMBLY

C	SHEET 1 PL MS20426AD3-5 RIVET WAS MS20426AD3-4, CR3213-4-03 RIVET WAS MS20470AD3-4, WASHER QTY WAS 6 (VIEWS UPDATED ACCORDINGLY). RIVETS ON SHEET 1 CHANGED TO REF QTY. RIVETS ON SHEET 2 CHANGED TO "HARD" CALLOUTS. SHADING REMOVED FROM ALL VIEWS FOR CLARITY.	AJS	08.09.02
B	ADD FINISH COAT & 1.0 TYP. SHEET 2 ZONES A, B & C.5. ADD MIN THICKNESS. SHEET 3 ZONE A, B	RF	08.06.24
A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	J	DRAWING NO.	REV. C
MFG. APPR.	E	D3690	SHEET 1 OF 3
APPROVED	10	TITLE	SCALE
DE APPR.	10	GLARESHIELD ASSEMBLY	NTS
DATE	08.09.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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TRANSFER DRILL $\varnothing 0.128$
FROM D3698-1 TO D3690-1
INSTALL
CR3213-4-03 RIVET, 20 PL
RIVET HEAD ON GLARESHIELD
OUTSIDE SURFACE

D3690-1
GLARESHIELD
REF

TRANSFER DRILL $\varnothing 0.098$
FROM D3697-041 TO D3690-1
INSTALL
MS20426AD3-5 RIVET
AN960JD3 WASHER (ON GLARESHIELD
OUTSIDE SURFACE)
1 PER SIDE

TRANSFER DRILL $\varnothing 0.128$
FROM D3697-041 TO D3690-1
INSTALL
CR3213-4-03 RIVET 2
BOTH ENDS

0.14
REF

SECTION A-A

EQUAL DIMENSION
AT BOTH ENDS

TRANSFER DRILL $\varnothing 0.128$
FROM D3697-041 TO D3690-1
INSTALL
CR3213-4-03 RIVET, 11 PL
RIVET HEAD ON GLARESHIELD
OUTSIDE SURFACE

TRANSFER DRILL $\varnothing 0.144$
AT THIS LOCATION
FROM D3697-041 TO D3690-1
(NO HARDWARE INSTALLED)

D3698-1
SUPPORT ANGLE
REF

D3690-041 GLARESHIELD ASSEMBLY

RELEASED
08-09-14

NOTES:

- 1) CENTER D3697-041 AND D3698-1 ON TO D3690-1
- 2) FINISH: PAINT D3690-041 ASSY FLAT BLACK USING BASF GLASURIT 22 LINE CODE SFA39.50 PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFICATION: ETCH WITH DART P/N D3690-041 & B/N ON INSIDE OF PART
- 5) WEIGHT: 2.98 lbs
- 6) MASK HATCHED AREAS (6 PLS) ON INSIDE OF THE PART PRIOR TO PAINTING

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG APPR.		D3690	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GLARESHIELD ASSEMBLY	NTS
DATE	08.09.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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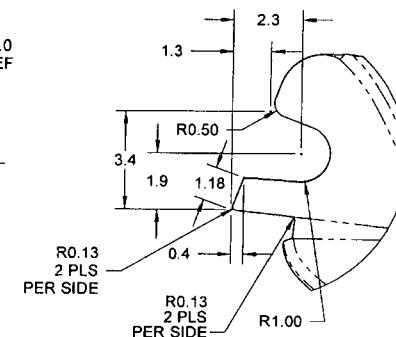
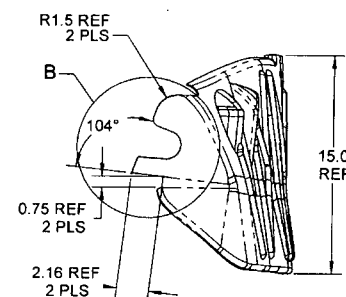
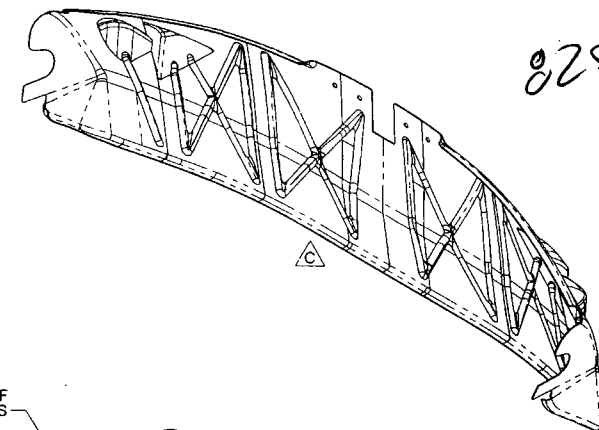
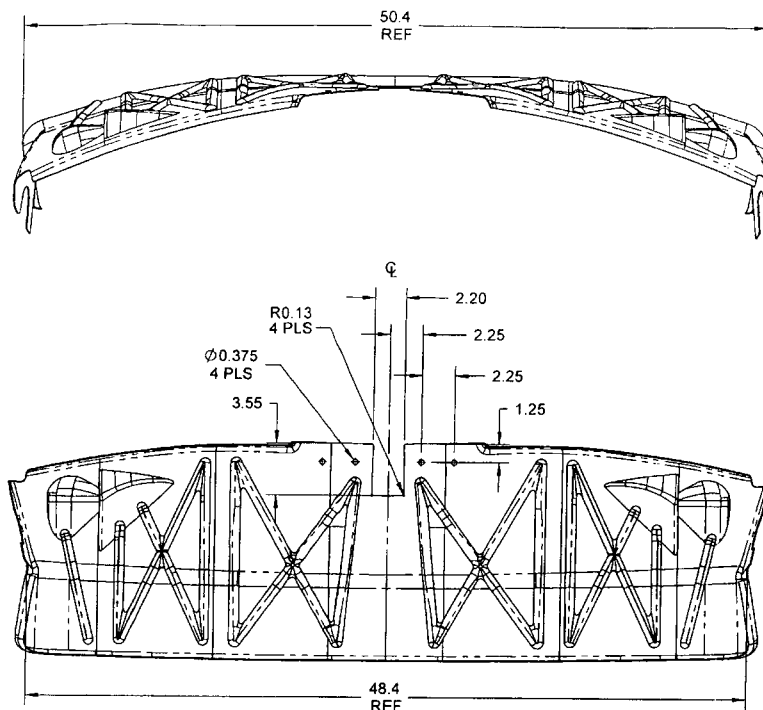
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D3690-1 GLARESHIELD

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED 701 BLACK FLAT LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 2) TOOLING: THERMOFORM PER MOLD DT9010 PER QSI 022
TRIM PER MOLD SCRIBE LINES EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 2.5 lbs
- 9) MINIMUM THICKNESS AFTER FORMING IS 0.040

RELEASED
07-07-14

DETAIL B
SCALE 2X
THIS VIEW FOR REFERENCE ONLY

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3690	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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